



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C60-19C
Job Sheet 171692



Part No: C60-19C

Job Qty: 1 ea

Part Name: Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/7/18

Job Tracking No:

Due Date: 2/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: C60-19C REV.3 IPP REV:A 18.02.02 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/27/18	0.00	0.00	Start Up Large Fab-7		EL
100	Large Fab	1 pcs		2/27/18	0.00	10.00	Large Fab 8		EL
110	QC	1 pcs		2/27/18	0.00	0.00	QC9		PD 18.04.17
120	QC	1 pcs		2/27/18	0.00	0.00	QC5		PD 18.04.17
130	Powdercoat	1 pcs		2/28/18	0.00	0.50	Powdercoat6		BR 18-4-18
140	QC	1 pcs		2/28/18	0.00	0.00	QC3		SP
150	Packaging	1 pcs		2/28/18	0.00	0.00	Packaging3-2		SP
160	QC21-SA	1 Ea		2/28/18	0.00	0.00	QC21		APR 18 2018

Part Op 100 - MANUFACTURE AS PER DWG, TACK WELD FOR INSPECTION BY: _____ USE WELDING JIG C45/60.

Descriptions: ***ALL HOLES MUST ALIGN***

130 - START TIME: 8:10 OVEN TEMPERATURE: 320 FINISH TIME: 8:40

M179203

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
C45-18-1	Lifting Plate	2 Ea (2 ea)	90-Start up Operation	
C45-18-5	Boss	2 Ea (2 ea)	90-Start up Operation	
C60-18-6	Bumper Bracket	1 Ea (1 ea)	90-Start up Operation	
MT-A513-T-1.000W0.120	A513 Seamless Alloy Steel Round Tubing 1"dia. x 0.120" Wall	20 ft (20 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	C45-18-1	2	0	0
	C45-18-5	2	8	0
	C60-18-6	1	0	0
	MT-A513-T-1.000W0.120	20	100	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval _____																		

Description Work Order Deviation	Disposition

Root Cause		FAULT CATEGORY	
Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐
OTHER : ☐			

1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com



Container No: S061591



Part: C60-19C
 Job No: 171692
 Serial No/Batch: S061591
 Revision: 3
 Inspector: _____

☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

Date: 04/17/18